

18/07/2008 1:20:04 PM

ecocq

Process Sheet

: CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ANGLE
 : 40666
 Estimate Number : 13281
 P.O. Number :
 This Issue : 18/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 38877
 Written By :
 Checked & Approved By : JUO 08 7.18
 Comment : Est Rev:A 08-04-25 new issue DD verified by:EC
 Est Rev:B 08-07-14 revB as per dwg DD verified by:ec

Part Number : D36981
 Drawing Number : D3698 REVB
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 08/08/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S032	6061-T6 Sheet 0.032"
-----	-------------	----------------------



Comment: Qty.: 0.4700 sf(s)/Unit Total : 0.9400 sf(s)
 6061T6 aluminium sheet .032" thick
 (M6061T6S032)
 Batch: 16954 HB 8-7-24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3698
 Dwg Rev: B
 Prog Rev: B

HB 8-7-24

(4)

****grain direction along 1.378" ****

2- Deburr if necessary HB 8-7-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S order 24 (4)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE





1-Bend 105 deg. angle as per Dwg D3698

SB 08/08/12

FF 08-08-14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3698-1 PAR #: N/A Fault Category: Sm. Fob NCR: Yes No DQA: JA Date: 08-08-22
D3690-041 (D412-776-041) QA: N/C Closed: AD Date: 08/08/25

NCR: <u>40666</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/19	# 5.0	During forming the two parts were bent too much and when operator tries to re form the part cracks		Scrap and Destroy no replace qty <u>(2)</u>	08/08/19 FF	 08/08/19	 08/08/22	 08/08/19
		R.C. parts were over bent.						

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:20:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 40666

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form curve as per dwg D3698 and verify using template DT9001

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/19 (X2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-08-19 (2)

8.0

POWDER COATING

POWDER COATING



M102316



(2X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:50

OVEN TEMPERATURE:

320 °F

FINISH TIME:

9:20

M-1 08/08/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-20 (2X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 43

C208/08/21

(X2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



M-1 08-08-21

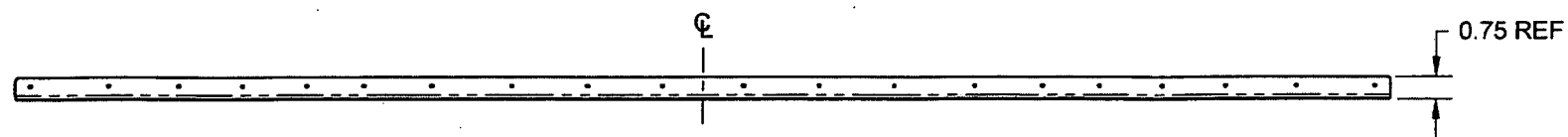
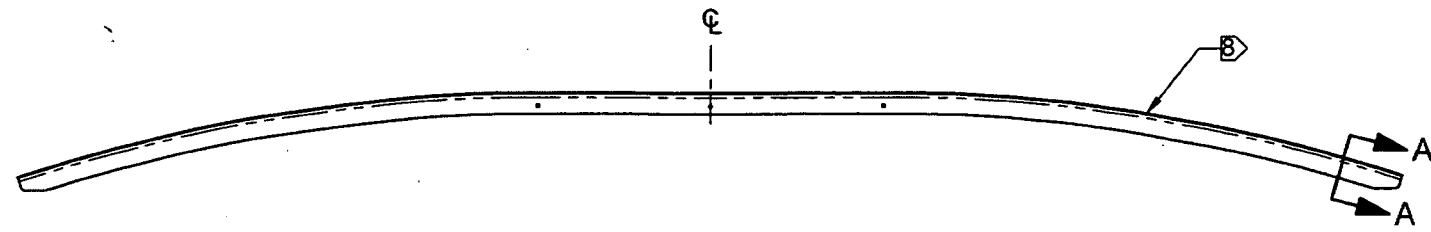
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

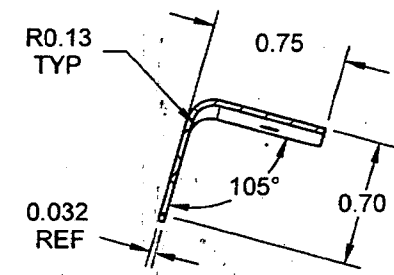
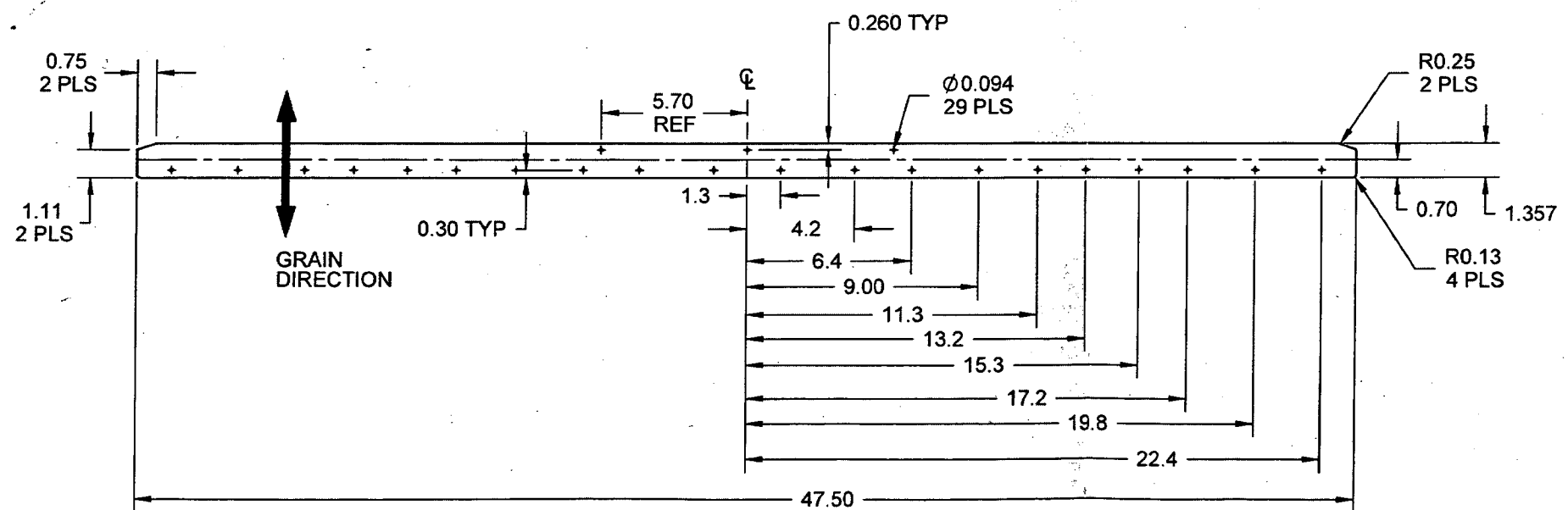
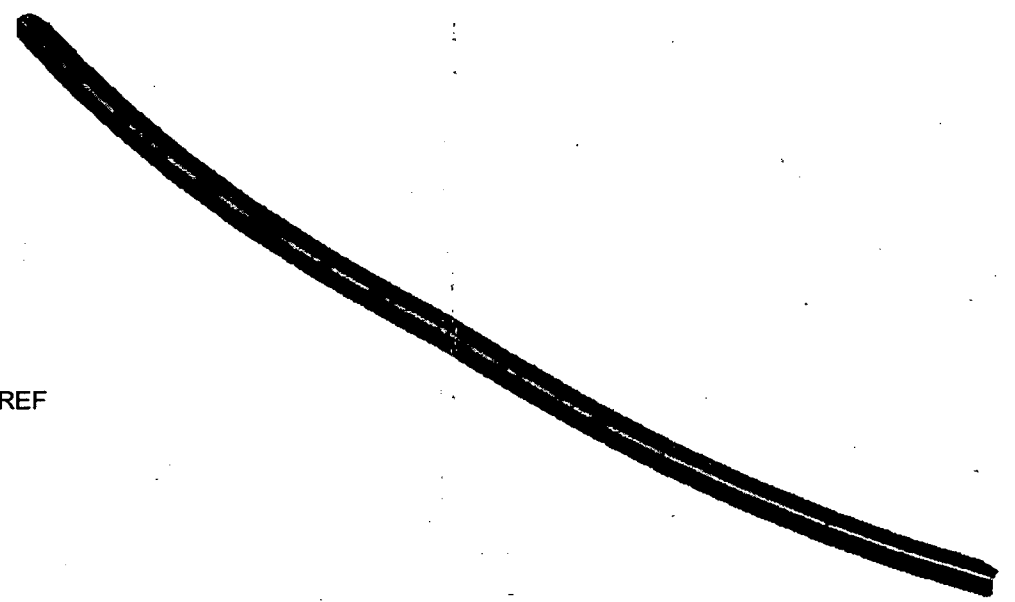
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



SECTION A-A

D3698-1F FLAT PATTERN

RELEASED
08-07-08

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4000

- NOTES:**
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK (REF. DART SPEC. M6061T6S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.20 lbs
 - 8) FORM AS PER TEMPLATE DT9001



B	REMOVE POWDER COAT. ZONE A,8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3698 REV. B SHEET 1 OF 1 TITLE SUPPORT ANGLE SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.02		

DART AEROSPACE LTD		Work Order: 40666
Description: SUPPORT ANGLE		Part Number: D3698-1
Inspection Dwg: D3698-1 Rev: PRE-L.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .094	+ .004 - .001	.095	+			
.260	+ .006 - .001	.257	+			
1.30						
47.50	+/- .030	47.48	*			
1.3	+/- .100	1.301	*			
4.2	+/- .100	4.211	*			
6.4	+/- .100	6.403	*			
9.00	+/- 1.00 .030	9.00	+			
11.3	+/- .100	11.3	+			
13.2	+/- .100	13.2	+			
15.3	+/- .100	15.3	+			
17.2	+/- .100	17.2	+			
19.8	+/- .100	19.8	+			
22.4	+/- .100	22.4	+			
.30	+/- .030	.308	*			
5.70	+/- .030	5.697	+			
1.11	+/- .030	1.10	+			
.75	+/- .030	.75	+			
1.357		1.358	+			

Measured by: RB	Audited by: S	Prototype Approval: 1/7
Date: 8-7-24	Date: 08/07/24	Date: 1/7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	